

Blue

Dart Aerospace Ltd.

Date: Wednesday, 12/11/2008 1:41:16 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLUE - LUG EXTRUSION
 Job Number : 43389 - 1
 Estimate Number : 10326
 P.O. Number :
 This Issue : 12/11/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D27317
 First Issue : / / Type : MACHINED PARTS Drawing Number : D2731 REV B
 Previous Run : 42568 Drawing Revision : B
 Material :
 Due Date : 10/12/2008 Qty: 100 Um: Each
 Written By :
 Checked & Approved By : Julie Dawson 08.11.12
 Comment : Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC

Additional Product

Split 1

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 7.1715 f(s)

Lug Extrusion D2423

Batch: B43722

2.0 BAND SAW BAND SAW



Cut @ meter

Comment: BAND SAW

Cut D2423 extrusion to .82"

Batch: _____

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

P/O: 7584 020811#114
Issue P/O meter

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2731-7.

2-Check for crack while loading into the machine.

3-Tumble

4-Deburr any rough edges after tumbling

Machine as per drawing

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



rec'd.

rec'd + inspect for transit damage

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

attached n+c

9/11/7 (100)

5.0 QC8 SECOND CHECK



counts

Comment: SECOND CHECK

5026108 (100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:41:16 PM
User: Julie Dawson

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Drawing Name: BLUE - LUG EXTRUSION

Job Number: 43389

Part Number: D27317

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(100)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 09/01/12

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: -PRIME B 110199

-PAINT DELFLEET BLUE B 110077

-CLEAR DELFLEET B 110161

ml 09 01 27

(X30)

8.0

QC14

INSPECT SPRAY PAINT



(X30)

Comment: INSPECT POWDER COAT

It 09 01 28

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(30x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Stuen

9/1/28

50

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/29

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-01-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

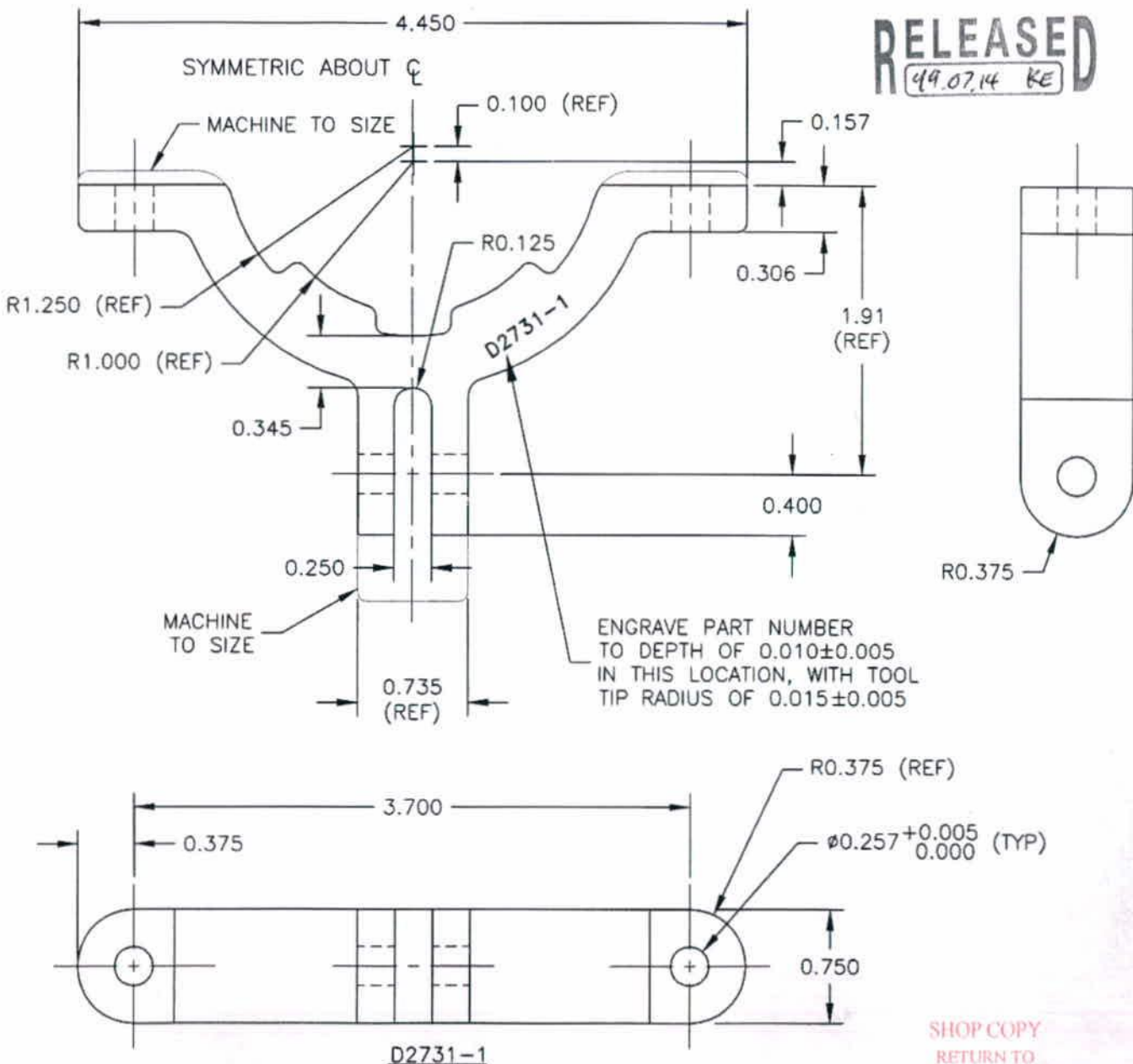
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>JS</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	



RELEASED
49.07.14 KE

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

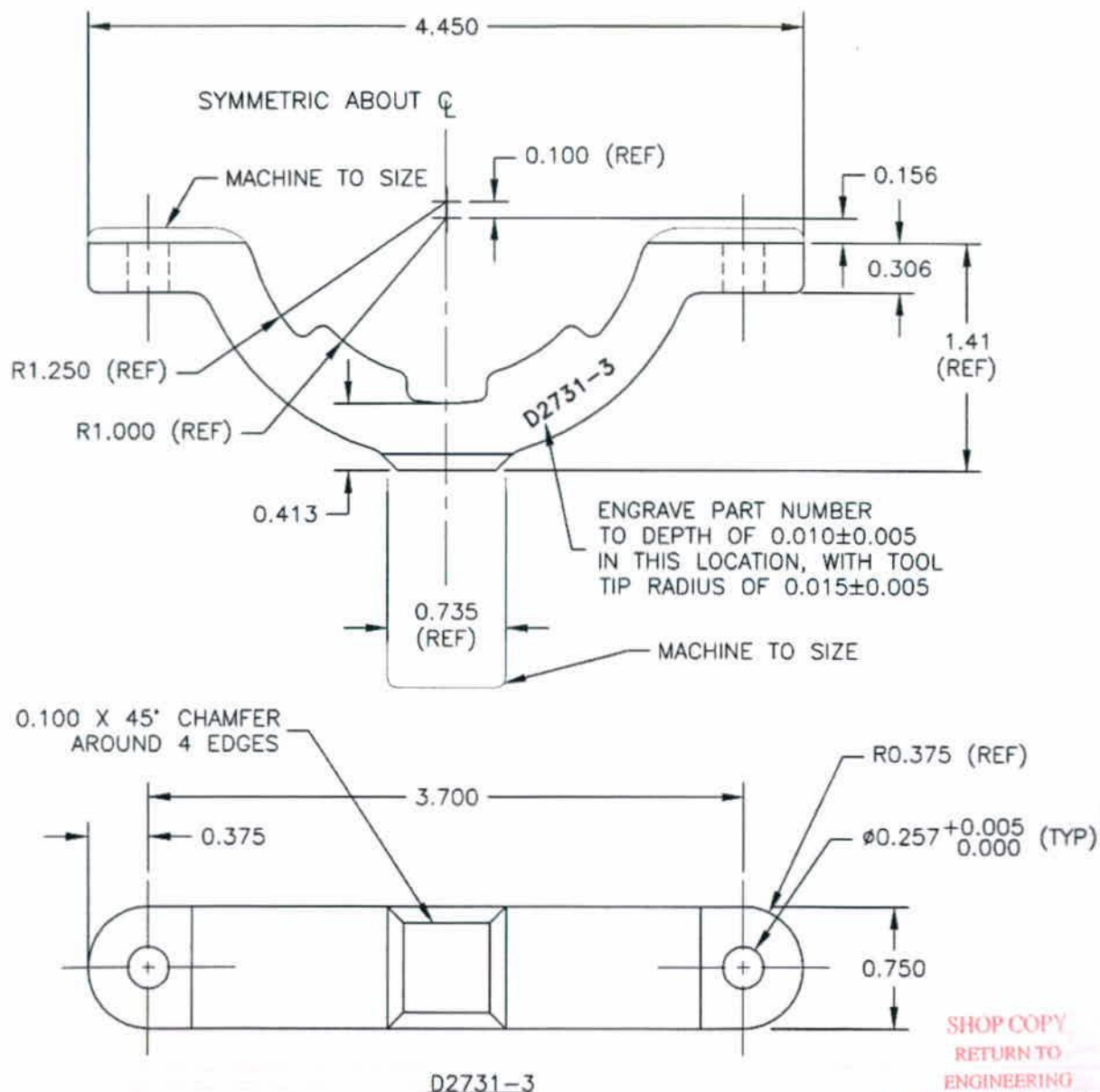
WITHOUT NOTICE

WORK ORDER

NO. 43389

DART

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>Q</i>	DRAWING NO. D2731	REV. B SHEET 2 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

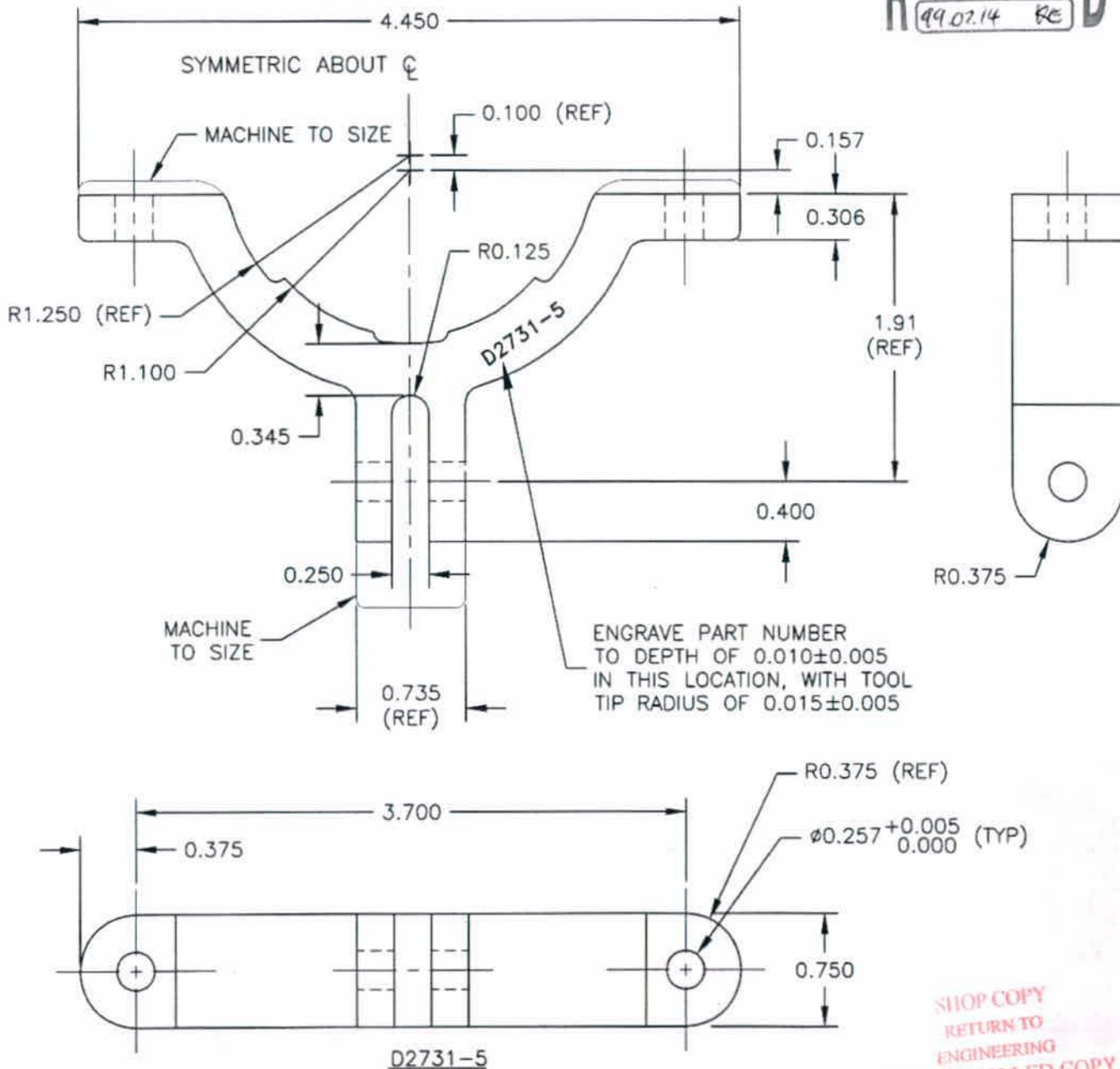
RELEASED
19.07.14 *KE*

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 3 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

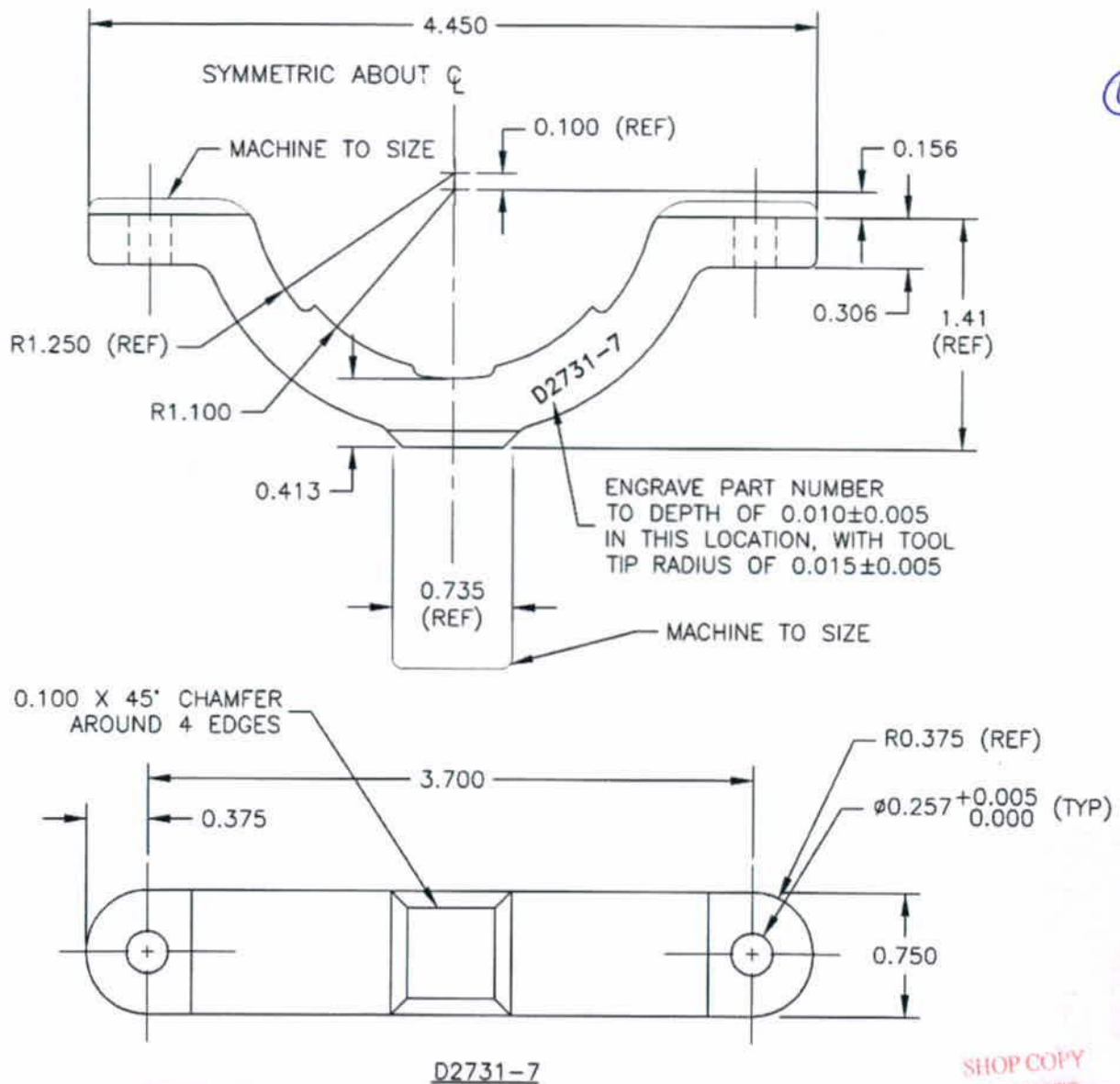
RELEASED
99.07.14 *RE*

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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

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99.07.14 *KE*

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

100

D2731-7

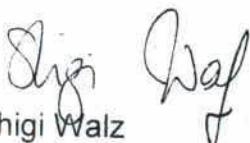
Mounting Lug

7584

MATERIAL: supplied by DART D2423 B43722

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz


S. Walz

Vankleek Hill, January 7, 2009